

Work Order ID 78816

78816

Page 1

January-16-12 11:22:04 AM

Item ID: D206-667-201TRN

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Turning Detail

Start Date: 15/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/16

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-241	Rev C								

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AA

DWG REV: 2

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

1 Ø
KC / man.L 12/03/28

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control

1 Ø
KC / man.L 12/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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1

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00							
120									
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA084								
	2-File down transition lines smooth.								
	3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file brush file repeatedly with file card.								
	FOLIO REV: <u>47</u>								
	DWG REV: <u>C</u>								
	*Do not use sandpaper coarser than 320 grit.								
130	QC1- Inspect dimensions to dimension sheet	0.00							
130									
QC	Memo	0.00							
Quality Control									

1 Ø

KE/Man.L 12/03/28

1 Ø

KE/Man.L 12/03/28

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January-16-12 11:22:04 AM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 16/01/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 30/01/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation	Description
1	Start
2	Read input
3	Process input
4	Output result
5	End

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 QC8- Inspect parts - second check

0.00

140

QC Memo

0.00

Quality Control

145 0.00

145

Crosstubes	Memo	0.00
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Crosstubes GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150	Crosstubes Chemical Conversion	0.00
-----	--------------------------------	------

150

HandFXtube	Memo	0.00
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Hand Finishing Crosstubes

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 ~~QC~~ Inspect Part Finish

0.00

160

QC

Memo

0.00

8/2/03/30

Quality Control

170

0.00

170

Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in kanban rackLocation: LG

MO 12-3-30

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/3/30 CL
12/03/30

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NOTE: Date & initial all entries

Picklist Print

January-16-12 11:22:08 AM

Page 1

Work Order ID: 78816

78816

Parent Item: D206-667-201TRN

D206-667-201TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified by:DD
IPP Rev:C 08-12-23 revc as per dwg DD verified by JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6003-102		Manufactured	No			110	Each	59.0000	1	1			

D6003-102

Crosstube, 206

Location

Loc Qty

Loc Code

LG

59

29116

12

38335

47

1 man L 12/03/27

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	78816
Description: Crosstube Assembly	Part Number:	D206-667-241
Inspection Dwg: D206-667-241 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	30° x .500	/			
	0.250	+/-0.010	.250	/		Vern	cwc-06
	2.240	+0.005/-0.000	2.245	/		↓	
	4.438	+/-0.030	4.438	/		↓	
	1.780	+0.005/-0.000	1.784	/		↓	
	R0.063	+/-0.010	.063	✓		RG	
	1.851	+0.005/-0.000	1.856	/		Vern	CNC-06
	1.928	+0.005/-0.000	1.922	/		↑	
	2.005	+0.005/-0.000	2.006	/		↓	
	2.082	+0.005/-0.000	2.087	/		↓	
	2.159	+0.005/-0.000	2.161	/		↓	
	2.190	+0.005/-0.000	2.193	/		↓	
SIDE B	30° x 0.500	+/-0.010	30 x .500	/		↓	
	0.250	+/-0.010	.250	/		Vern	cwc-08
	2.240	+0.005/-0.000	2.245	/		↓	
	4.438	+/-0.030	4.478	/		↓	
	1.780	+0.005/-0.000	1.783 1.785	/		↓	
	R0.063	+/-0.010	.063	✓		RG	
	1.851	+0.005/-0.000	1.856	/		Vern	CNC-06
	1.928	+0.005/-0.000	1.922	/		↑	
	2.005	+0.005/-0.000	2.007	/		↓	
	2.082	+0.005/-0.000	2.087	/		↓	
	2.159	+0.005/-0.000	2.163	/		↓	
	2.190	+0.005/-0.000	2.191	/		↓	
	100.60	+/-0.020	100.6	/		tape	mm-0

Measured by: mmL/KC	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12/03/27	Date: 12-3-28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	
B	09.05.20	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ULTRA SONIC MEASUREMENTS

Side	LOCATION on tube	R1	R2	R3	R4
A		.253	.356		
		.248	.338		
		.257	.353		
		.266	.358		
B				.261	.359
				.249	.338
				.266	.339
				.258	.346

Part number	D206-667-201 TRN
Batch number	78816
Measured By	KC / gnm

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOWN BY
K
UNCONTROLLED COPY
SUBJECT

NO. 78816 M.C.J

12/01/16

UNDER REVIEW

RELEASED
06/14/12 NRP

DEO ATTACHED

C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-241	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

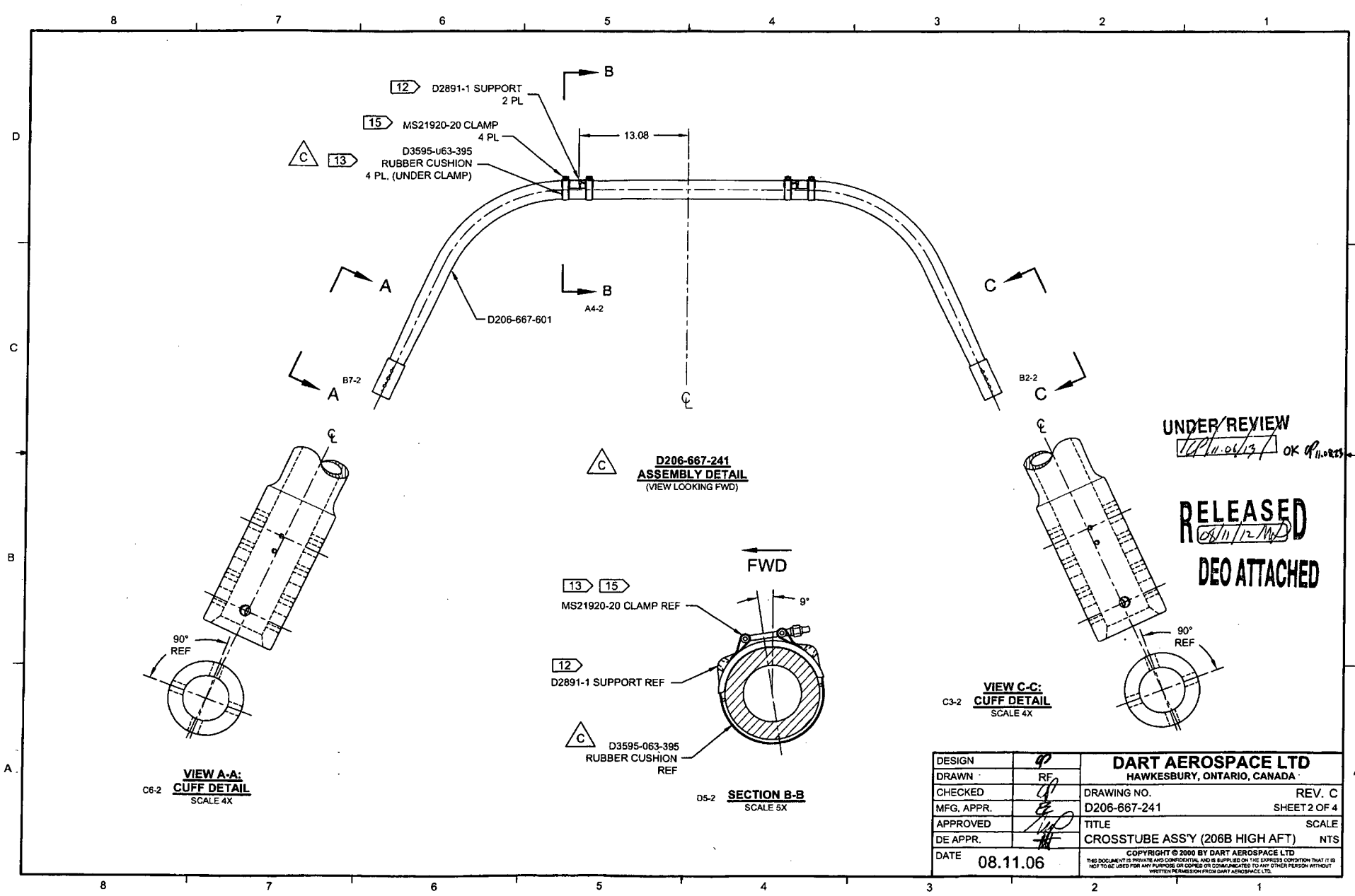
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NOTE: Date & initial all entries

70816



UNDER REVIEW
 11/01/13 OK P. 11.08.13
 RELEASED
 08/11/12 M.D.
 DEO ATTACHED

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. C
MFG. APPR.	90	D206-667-241	SHEET 2 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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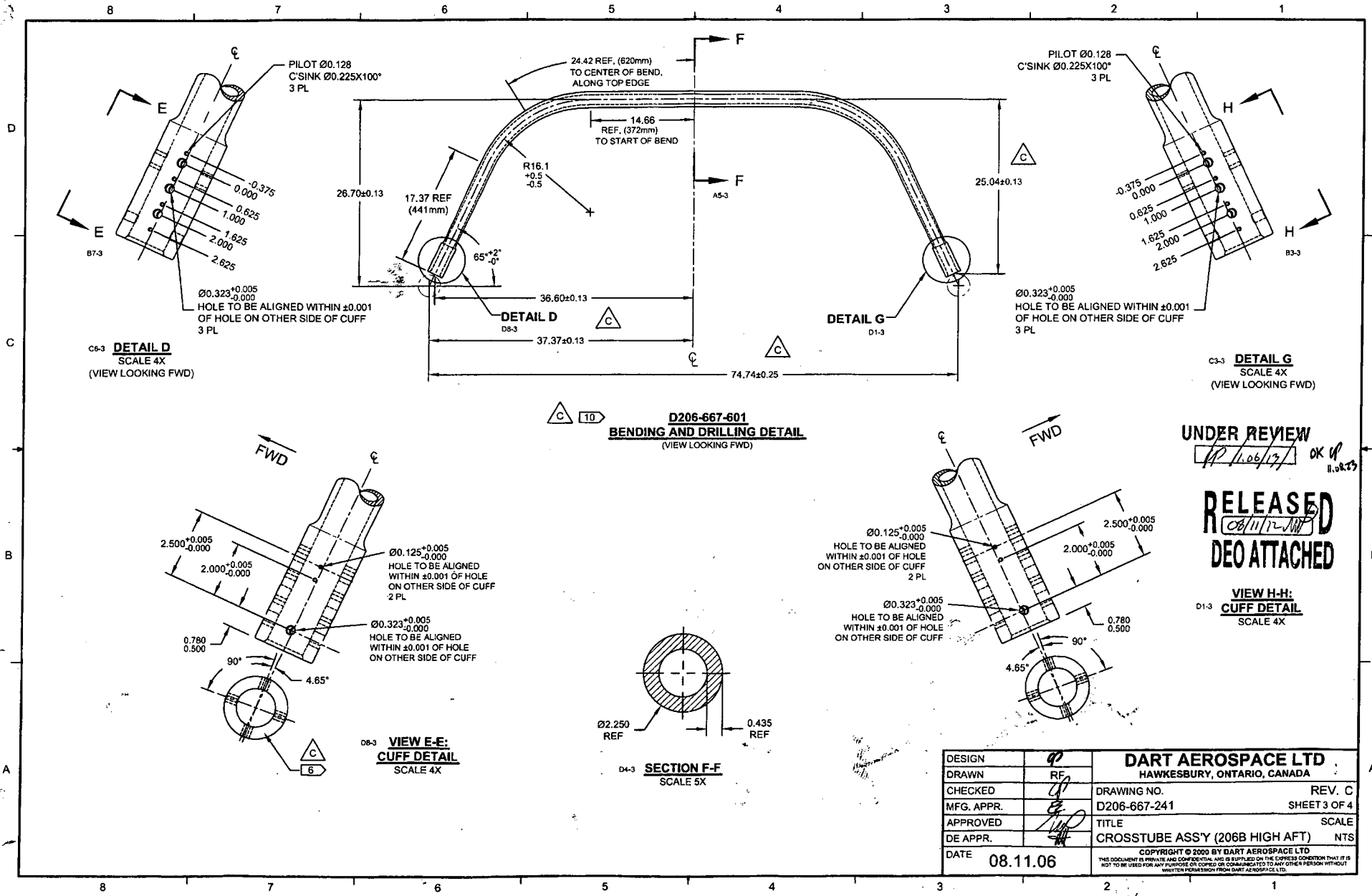
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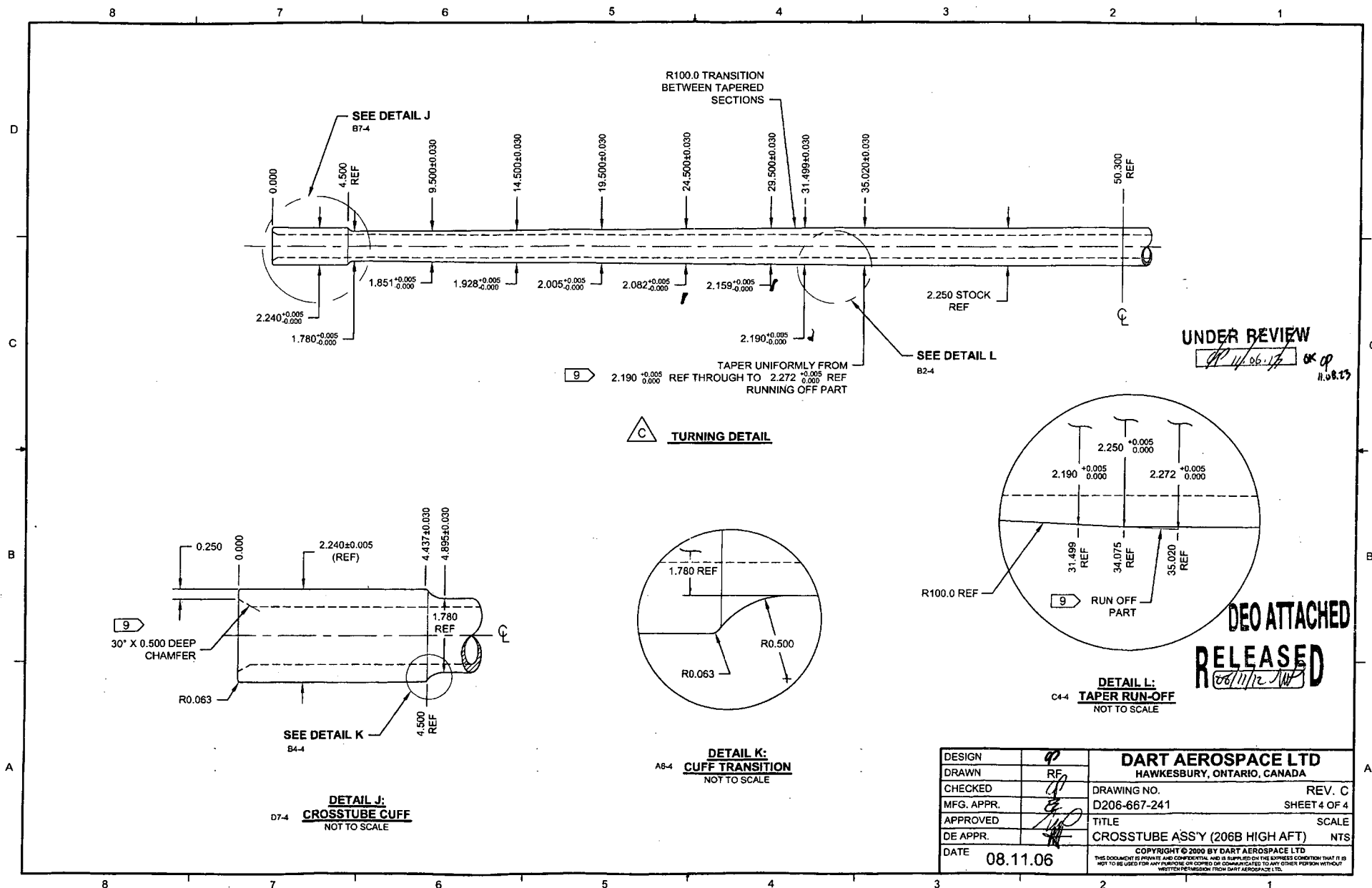
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DRAWING NO. D206-667-241	TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-241-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>AS</i>	MFG. APPR. <i>A</i>	APPROVED <i>W</i>		DE APPR. <i>H</i>		
DATE 11.07.15	DATE 11.08.22	DATE 11.08.22	DATE 11/08/22		DATE 11.08.22		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:**IS:**

Item	Qty -241	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-08-23
W

W/O:		WORK ORDER CHANGES					
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